

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013715**Date Inspected:** 15-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhou cheng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#14

Ultrasonic testing of following joints notified for inspection by ZPMC NWIT 005525, but when we went for inspection it is found that 3 joints SEG3006A-011,012,010 not completed by ZPMC UT personnel. This is informed to ZPMC QC Mr. Li ming yang he agreed and cancelled the notification.

OUTSIDE SHOP

SMAW welding of weld joint 3G-001 on PCMK SSD17-PP93 of 10CE welder is identified as 050969.ZPMC QC is identified as Mr.Li yang hua. The welding variables recorded by QC appeared to comply with the WPS-B-P-2213-Tc-U4b-FCM-1.

BAY#19

FCAW welding of weld joint 2G-001 on PCMK USPL1-963 of segment U-ribs splice welder is identified as 062761.ZPMC QC is identified as Mr.Zhou cheng. The welding variables recorded by QC appeared to comply with the WPS-B-P-2232-Tc-U4b-F.

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FCAW welding of weld joint 2G-002 on PCMK USPL1-469 of segment U-ribs splice welder is identified as 062783.ZPMC QC is identified as Mr.Zhou cheng. The welding variables recorded by QC appeared to comply with the WPS-B-P-2232-Tc-U4b-F.

BLAST SHOP#1

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of Segment 9CE internal Deck panel , corner assembly and deck panel diaphragm connecting to floor beam from panel point PP77 to PP78 after grit blasting. Areas that marked for repair were recorded for future repair. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

DP394-001-140, 3mm porosity found taped for future repair.

DP448-001-132, 3mm porosity found taped for future repair.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Chadra	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
